

Date: Monday, 1/7/2008 3:38:19 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, RH, 206
 Job Number : 36626
 Estimate Number : 10523
 P.O. Number :
 This Issue : 1/7/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 34780
 Part Number : D26652
 Drawing Number : D2665 REV. D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 1/31/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : *JA 08.01.8*
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in
 house process EC
 Est Rev:D As per Rev D 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

B34873 x 3parts

DIP 08/05/02
B34644 x 9parts

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

DIP 08/05/01 / 18 08/05/04

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

DIP 08/05/02

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/05/02

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

20 08/05/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 36626

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



12x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

27/m

08/05/09

7.0

POWDER COATING

POWDER COATING



m 107550

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

08/05/09 12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JS 08/05/09 12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 436

JS

08/05/12 12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 36026
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.124	0.123	0.122	0.122		
B	0.100	0.140		0.115	0.117	0.117	0.116"		
C	1.125	1.145		1.137	1.136	1.134	1.134"		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.250	0.251	0.250	0.255"		
F	1.313	1.343		1.3265	1.326	1.326	1.3285		
G	0.210	0.230		0.222	0.222	0.220	0.220		
H	0.100	0.180		0.160	0.160	0.160	0.151"		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.5745	1.574	1.573	1.570"	✓	
K	0.235	0.240		0.237	0.238"	0.238"	0.238"		
L	0.100	0.120		0.108	0.108	0.108	0.108		
M	0.990	1.010		1.000	0.999"	0.998"	1.003"		
N	0.510	0.515		0.510	0.511"	0.511"	0.511"		
O	5.990	6.010		6.000	6.008"	6.002"	6.003"		
P	1.245	1.255		1.250	1.251"	1.251"	1.251"		
Q	2.495	2.505		2.498	2.501"	2.501"	2.501"		
R	0.313	0.318		0.314	0.314"	0.314	0.314"		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.499	2.500	2.498	2.499		
U	1.357	1.367		1.361	1.362	1.360	1.362		
V	0.787	0.807		0.796	0.796	0.796	0.798"		
W	0.540	0.560		0.549	0.552	0.553	0.555"		
X	1.674	1.684		1.677	1.679	1.677	1.677		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.912	0.932		0.910	0.920	0.920	0.927"		
AA	0.490	0.510		0.501	0.500"	0.505"	0.505"		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP / J.F.
Date: 08/05/02

Audited by: RP
Date: 08/05/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 36626
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min.	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.122	.122"	.118"	.114		
B	0.100	0.140		.115"	.116"	.115"	.116		
C	1.125	1.145		1.133"	1.134"	1.132"	1.129		
D	0.615	0.685		0.675	.675"	.675"	.665		
E	0.240	0.260		.255"	.254"	.255"	.255		
F	1.313	1.343		1.325	1.320	1.320"	1.321		
G	0.210	0.230		0.220	.215"	.215"	.214		
H	0.100	0.180		.167"	.167"	.167"	.165		
I	2.470	2.510		2.495	2.495"	2.495"	2.495		
J	1.565	1.585		1.569"	1.572"	1.571"	1.570		
K	0.235	0.240		.238"	.238"	.238"	.238		
L	0.100	0.120		.108"	.108"	.108"	.108		
M	0.990	1.010		.999"	.999"	.999"	1.000		
N	0.510	0.515		.511"	.511"	.511"	.510		
O	5.990	6.010		6.005"	6.003"	6.003"	6.003		
P	1.245	1.255		1.251"	1.251"	1.251"	1.250		
Q	2.495	2.505		2.501"	2.501"	2.501"	2.500		
R	0.313	0.318		0.314"	0.314"	0.314"	.313		
S	0.315	0.322		0.322"	0.322"	0.322"	.321		
T	2.495	2.505		2.500"	2.500"	2.500"	2.500		
U	1.357	1.367		1.362"	1.362"	1.362"	1.362		
V	0.787	0.807		.798"	.797"	.797"	.798		
W	0.540	0.560		.554"	.555"	.555"	.555		
X	1.674	1.684		1.677"	1.677"	1.677"	1.674		
Y	0.257	0.262		0.259"	0.258"	0.258"	.258		
Z	0.912	0.932		.925"	.927"	.927"	.927		
AA	0.490	0.510		.505"	.505"	.505"	.505		
AB	0.178	0.198		0.188"	.188"	.188"	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>DP/J.F.</i>	Audited by: <i>29</i>
Date: <i>01/15/08</i>	Date: <i>08/05/08</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36626
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	110	12	By	Date
A	0.100	0.140		.116	.121	.121	.121		
B	0.100	0.140		.117	.119	.119	.120		
C	1.125	1.145		1.129	1.135	1.125	1.120		
D	0.615	0.685		.675	.665	.665	.667		
E	0.240	0.260		.254	.254	.254	.254		
F	1.313	1.343		1.320	1.320	1.320	1.320		
G	0.210	0.230		.215	.219	.219	.219		
H	0.100	0.180		.126	.166	.166	.166		
I	2.470	2.510		2.495	2.495	2.499	2.495		
J	1.565	1.585		1.567	1.567	1.567	1.568		
K	0.235	0.240		.235	.235	.235	.235		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.003	1.002	1.002	1.002		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.002	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.554	.553	.553	.553		
X	1.674	1.684		1.674	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.927	.927	.927	.927		
AA	0.490	0.510		.505	.505	.505	.505		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

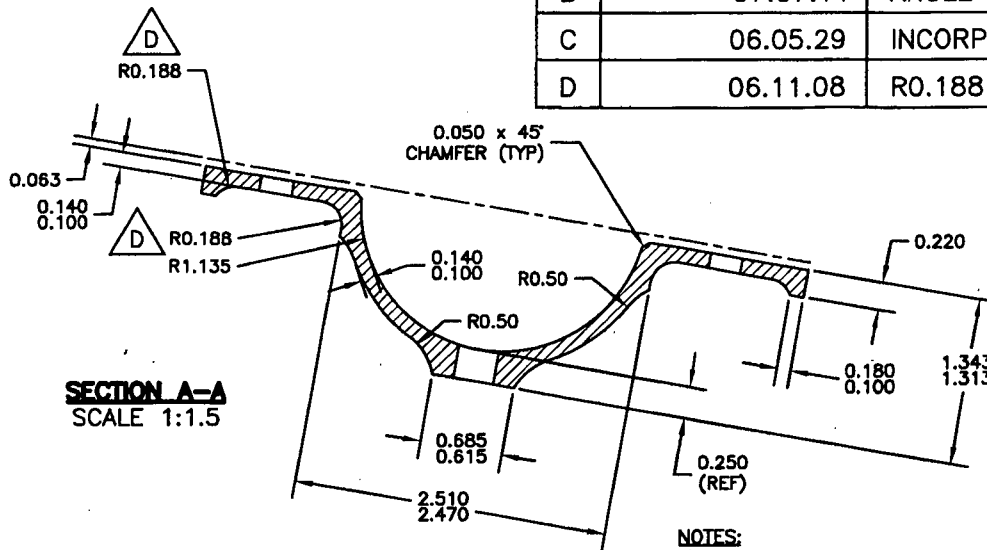
Measured by:	21
Date:	08/05/04

Audited by:	2P
Date:	08/05/08

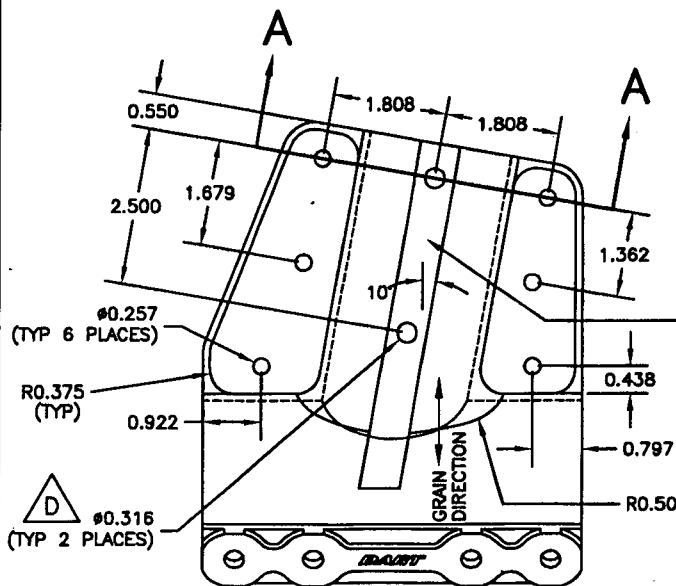
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

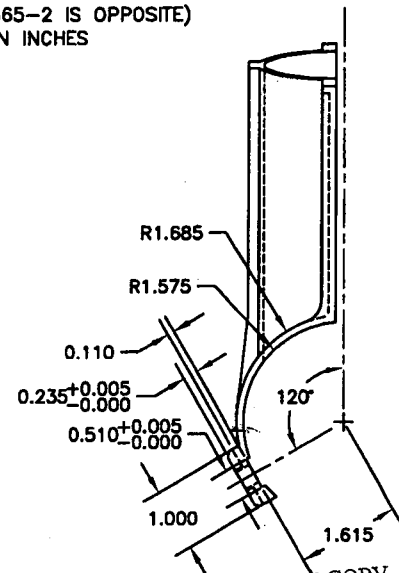
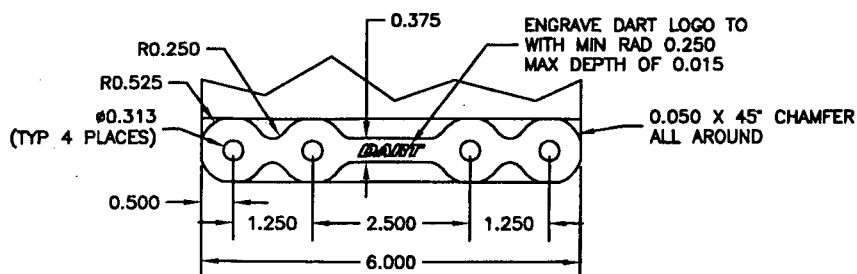
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



SHOP COPY
RETURN TO
ENGINEERING

D2665-1 SADDLE FWD OUTSIDE HIGH

WITHOUT NOTICE
WORK ORDER

NO. 36626

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